

Date: Friday, 02/05/2008 7:03:39 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 CABINE HEATER TUBE ASSEMBLY		
Job Number	: 38976		Part Number	: D2003049		
Estimate Number	: 11922		Drawing Number	: UNDER REVIEW <i>(u)</i>		
P.O. Number	:		Project Number	: N/A		
This Issue	: 02/05/2008	S.O. No.	:	Drawing Revision	: B	
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 09/05/2008	Qty: 5 Um: Each
Previous Run	: 30134					
Written By	:					
Checked & Approved By	:					
Comment	: Est B 03.03.31 Reformat KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 2.9750 f(s)/Unit Total : 14.8748 f(s) 304 RD Tube .500 x .035W Cut tube Ø 0.500" x 0.035" wall as per template D2003-049T1 (34.00" long) Material: AISI 304 SS tubing(M304TR0.500x0.035) Batch: <i>M107967</i>	<i>5 x 34"</i>
2.0	D2182045	Heat Shrink 4.5" Long	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Heat Shrink 4.5" Long Cut: Qty Part Number Description Batch 1 D2182-045 Heat Shrink <i>A110</i>	<i>ml 08/05/13 x5</i> <i>Use D2182-080</i> <i>B17067</i> <i>ml 08/05/13</i>
3.0	M26506	Firesleeve-crkl .375IDia	
		Comment: Qty.: 2.9050 f(s)/Unit Total : 14.5252 f(s) Firesleeve-crkl .375IDia Cut: Qty Part Number Description Batch 1 M2650-6 Heat Sleeve <i>M107746</i>	<i>(5 x 33.2")</i> <i>ml 08/05/13</i>

W/O:		WORK ORDER CHANGES					
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 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Description :

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut 33.2" long Heat sleeve as per Dwg D2003 & heat shrink

Form tube as per template D2003-049T2

ml 08/05/13 x5

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/13 (x5)

6.0 AN8188J

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN818-8J	Nut	M107959

✓

ml 08/05/13 x10

7.0 MS208198J

Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Sleeve

Pick:

Qty	Part Number	Description	Batch
2	MS20819-8J	Sleeve	M107799

✓ ml 08/05/13 x10

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2003

Install Red decal and heat shrink as per PPP D2003-049

ml 08/05/13 x5

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/13 (x5)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST (a3)

AS 08/05/14 (1)

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Seq. #: Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/15 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.05.14

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DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D2003	SHEET 1 OF 2
99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	
A	90.04.09	NEW ISSUE	
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

RELEASED
49.06.08 KE

UNDER REVIEW

CL.03.21 CB

Some flat
length wrong

W038976

P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20818-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/87}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	—2	2	—	—			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2003
DATE	99.06.08	TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS

REV. B

SHEET 2 OF 2

SCALE

RELEASED

99.06.09 KE

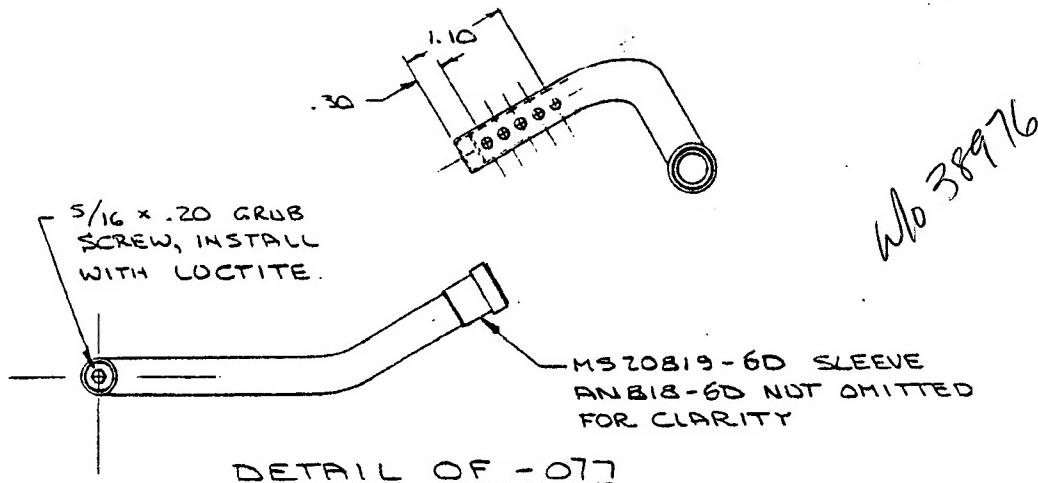
Notes:

UNDER REVIEW

06.08.21 CB

Some flat lengths
~~were~~ wrong

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



Dart Aerospace Ltd

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